

Date: Friday, 8/31/2007 11:53:34 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOOR	
Job Number	: 34377				
Estimate Number	: 12264				
P.O. Number	: N/A		Part Number	: D3140103	
This Issue	: 8/31/2007 S.O. No. : N/A		Drawing Number	: D3140 REV F	
Prsh Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: F	
Previous Run	: 27371		Material	: N/A	
Written By			Due Date	: 9/4/2007 Qty: 6 Um: Each	
Checked & Approved By					
Comment	: Est Rev:A New Issue 06-02-08 JLM Est. Rev B 06.04.18 New dwg rev. ecn781 EC Est. rev.C added scuffing NCR 061 EC Est Rev:D As per ECN #829 06-11-20 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S032	2024-T3 .032 sheet
	Comment: Qty.: -0.0578 sf(s)/Unit Total : 0.3465 sf(s) 2024-T3 .032 " Thick sheet (M2024T3S032)	
	Batch: M100284 HB 07-09-02	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3140 Dwg Rev: K1 Prog Rev: E	
	HB 07-09-02	(b)
	2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	
	HB 07-09-02	x6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/09/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 8/31/2007 11:53:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: DOOR
Job Number: 34377		Part Number: D3140103
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Scuff surfaces with 80grit sandpaper per QSI 006 2-Deburr. No sharp edges		
SB 07/09/10		
6.0	BRAKE NC	NC BRAKE
		
Comment: NC BRAKE Form as per Dwg D3140		
SD 07/09/10		
7.0	QC5	INSPECT WORK TO CURRENT STEP
		
Comment: INSPECT WORK TO CURRENT STEP		
Ep 07/09/10 (6) counter		
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
07-09-11 (6)		
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
Ep 07/09/11 (6)		
10.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST 177		
Ep 07/09/11 (6)		
11.0	QC21	FINAL INSPECTION/W/O RELEASE
		
Comment: FINAL INSPECTION/W/O RELEASE		
D 07/09/11 (6)		
Job Completion		
U 07.09.11		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>44</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>J.D.H.</i>	APPROVED <i>H.H.</i>	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION		
X						D3140-05	DOOR		
	X					D3140-06	DOOR		
		X				D3140-07	DOOR		
			X			D3140-08	DOOR		
				1	X	D3140-09	DOUBLER ASSEMBLY		
					1	D3140-10	DOUBLER ASSEMBLY		
3	3					D3140-57	PAD		
1	1					D3140-59	PAD		
2	2					D3140-61	PAD		
2	2					D3140-63	PAD		
				1	1	D3140-69	PAD		
					1	D3140-71	PAD		
					1	D3140-73	PAD		
					1	D3140-75	PAD		
					1	D3140-77	PAD		
					1	D3140-79	PAD		
						1	ANGLE		
1	1					D3140-85			
					1	D3140-87	DOUBLER	SHOP COPY	
					1	1	D3140-89	DOUBLER	RETURN TO
						1	D3140-91	DOUBLER	ENGINEERING
						1	D3140-92	DOUBLER	
3	3					D3140-95	DOUBLER	UNCONTROLLED COPY	
1						D3140-97	DOUBLER	SUBJECT TO AMENDMENT	
	1					D3140-98	DOUBLER	WITHOUT NOTICE	
				1	1	D3140-99	DOUBLER	WORK ORDER	
				2	2	D3140-101	DOUBLER	<i>3437</i>	
				1		D3140-103	DOUBLER		
					1	D3140-104	DOUBLER		
					1	D3140-105	DOUBLER		
					1	D3140-106	DOUBLER		
1	1					D3140-241	DOUBLER		
1		1				D3140-301	DOUBLER		
	1		1			D3140-303	DOUBLER		
					5	MS20426AD3-4	RIVET		

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DART

DESIGN <i>A</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JLH</i>	APPROVED <i>CH</i>	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06	TITLE DOOR	SCALE NTS	



COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
 MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
 MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
 FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM



FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S



MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED

06.11.13



MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECCELL



ALL DIMENSIONS IN INCHES



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION



DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION



RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130



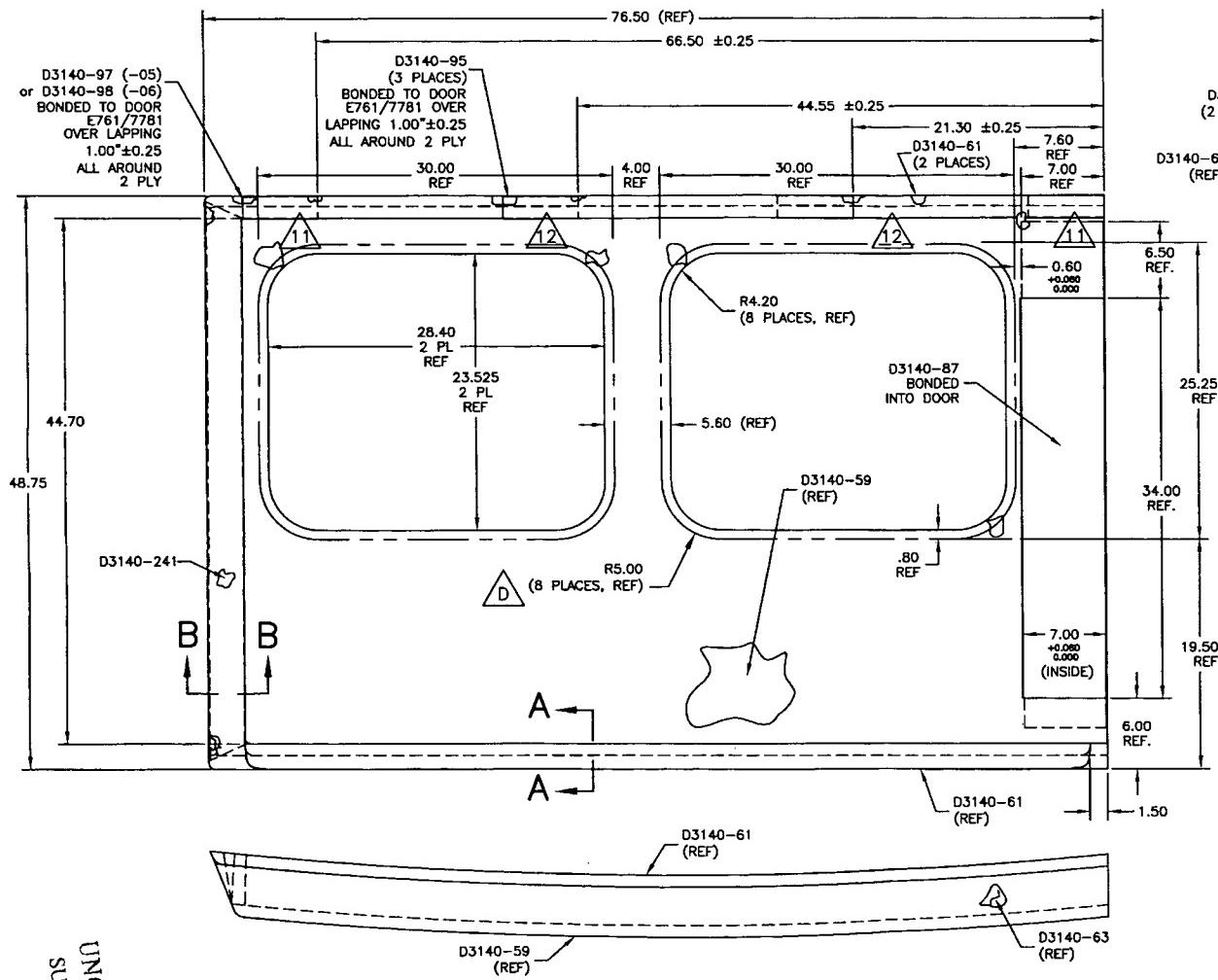
PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
 ALODINE PER DART QSI 005 4.1

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. *34377*



Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

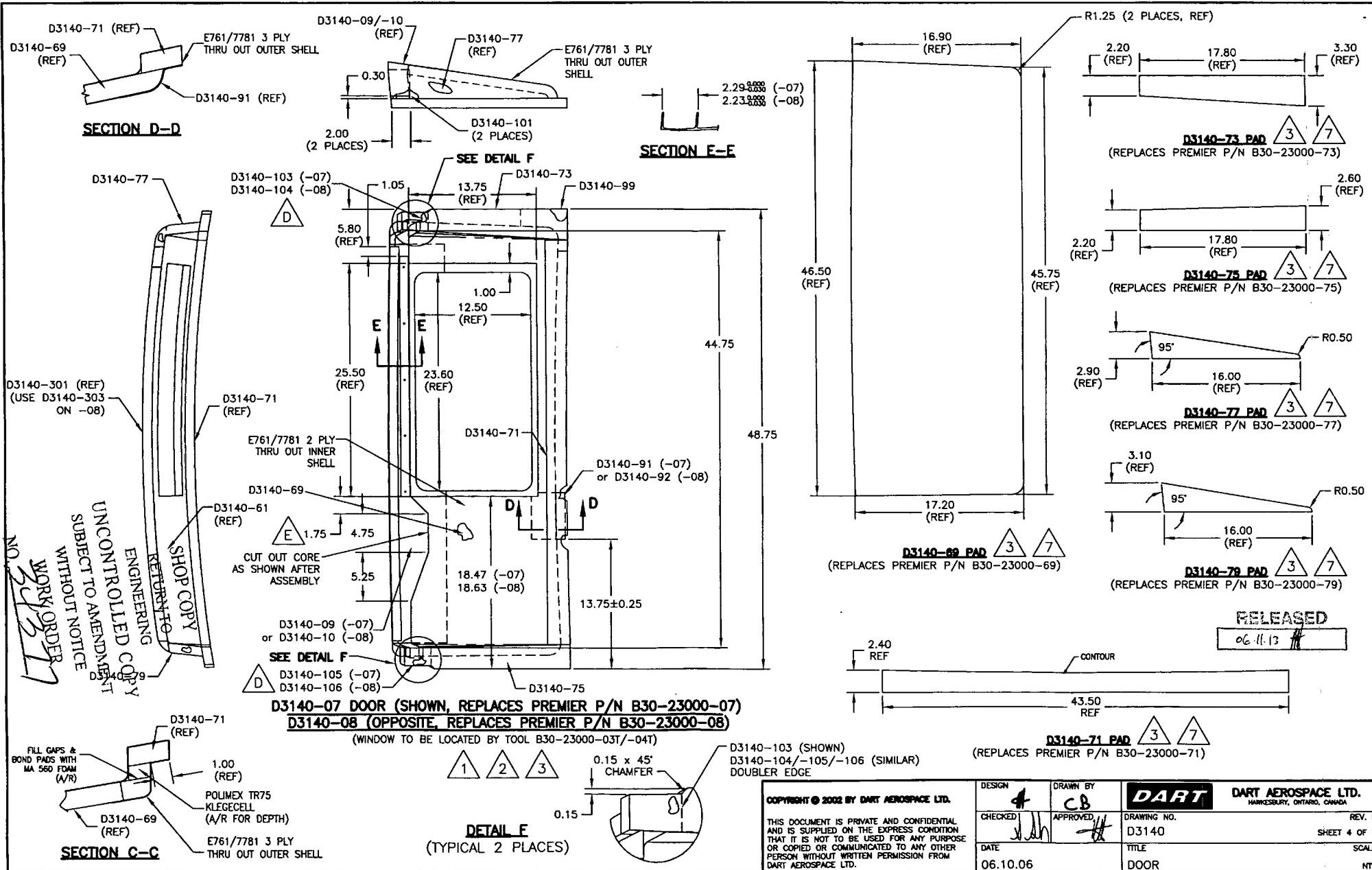


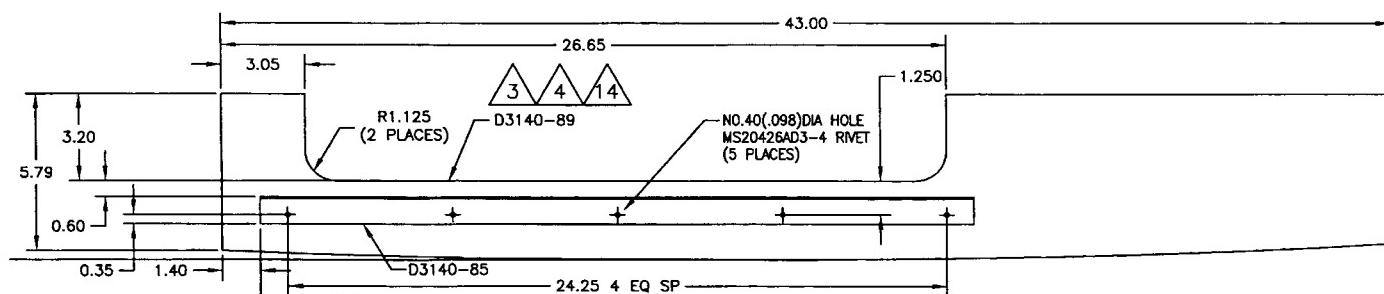
COMMERCIAL © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DARTE AEROSPACE LTD.

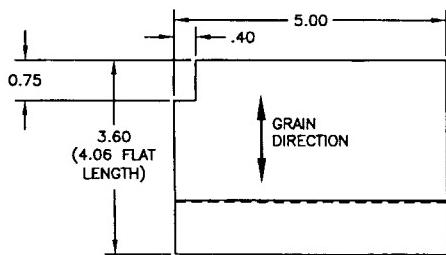
COPYRIGHT © 2002 BY DART AEROSPACE LTD.		DESIGN <i>#</i>	DRAWN BY <i>CB</i>	DART	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>			DRAWING NO. D3140	REV. F	SHEET 3 OF 7
DATE 06.10.06			TITLE DOOR	SCALE MTS		

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3437

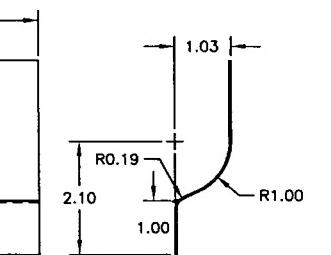




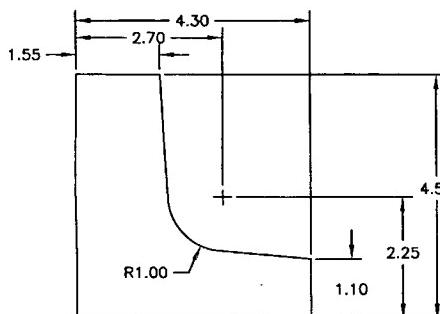
D3140-09 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-09)
D3140-10 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-10)



D3140-91F DOUBLER
(USE TO MAKE D3140-91/-92 DOUBLERS)



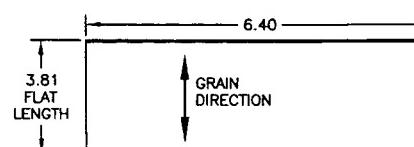
D3140-92 DOUBLER **D3140-91 DOUBLER**
(Shown, Replaces Premier P/N B30-23000-92)
(OPPOSITE, Replaces Premier P/N B30-23000-91)



D3140-99 DOUBLER
(REPLACES PREMIER P/N B30-23000-99)

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 2013
RETURN TO
ENGINEERING

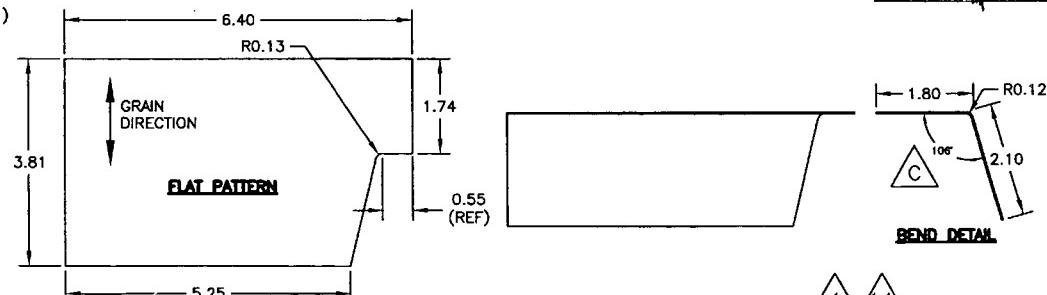
SHOP COPY



D3140-85 DOUBLER
(REPLACES PREMIER P/N B30-23000-95)

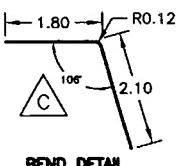
RELEASED

06-11-13



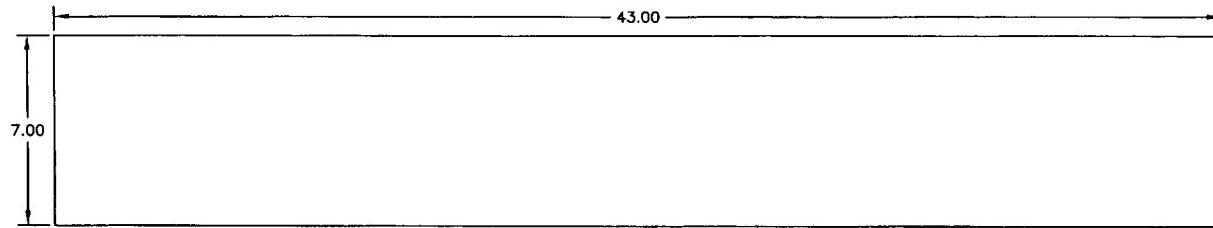
D3140-97F DOUBLER
(USE TO MAKE D3140-97/-98 DOUBLERS)

D3140-98 DOUBLER
(SHOWN, Replaces Premier P/N B30-23000-97)
(OPPOSITE, Replaces Premier P/N B30-23000-98)

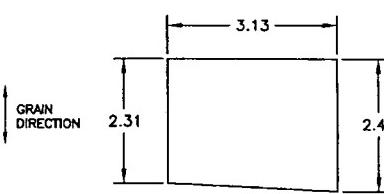


BEND DETAIL

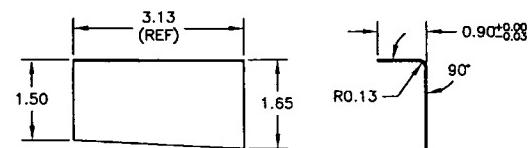
COPYRIGHT © 2002 BY DART AEROSPACE LTD.		DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. MURRAYSBURG, ONTARIO, CANADA
CHECKED		4	CB		REV. F
					SHEET 5 OF 7
DATE					SCALE
06.10.06					NTS
TITLE					
DOOR					



D3140-87 DOUBLER 4 14
(REPLACES PREMIER P/N B30-23000-87)

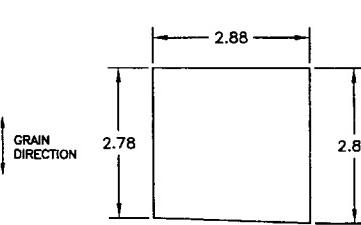


D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)

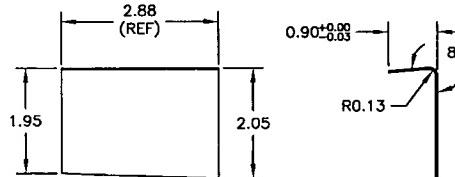


D3140-105 DOUBLER
D3140-106 OPPOSITE

4 14 D



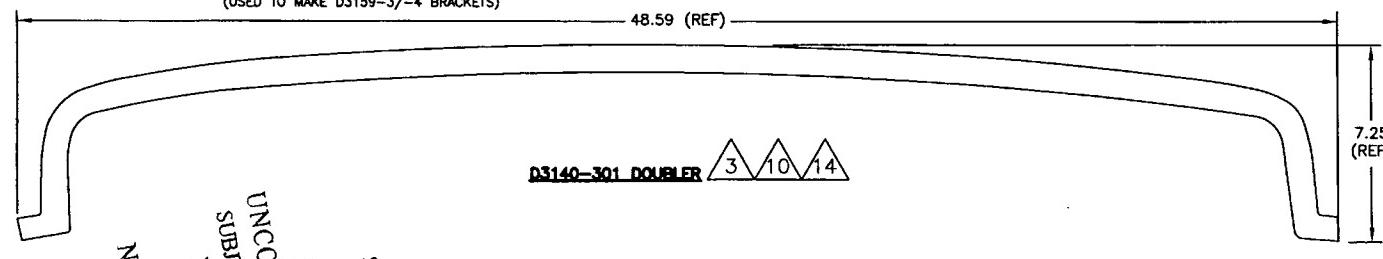
D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



D3140-104 DOUBLER
D3140-103 OPPOSITE

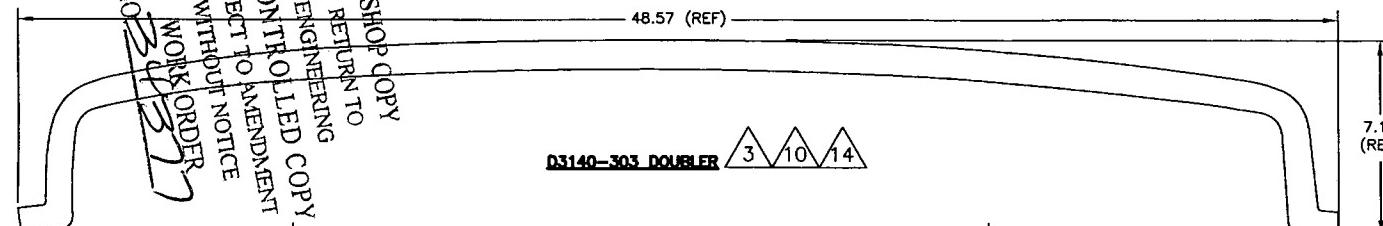
4 14 D F

D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)

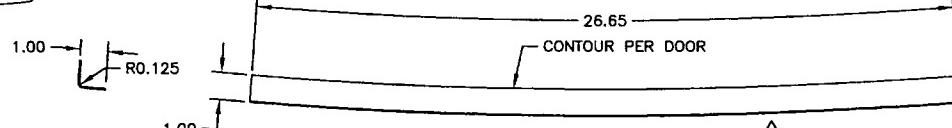


RELEASED
06.10.13

D3140-301 DOUBLER 3 10 14



D3140-303 DOUBLER 3 10 14

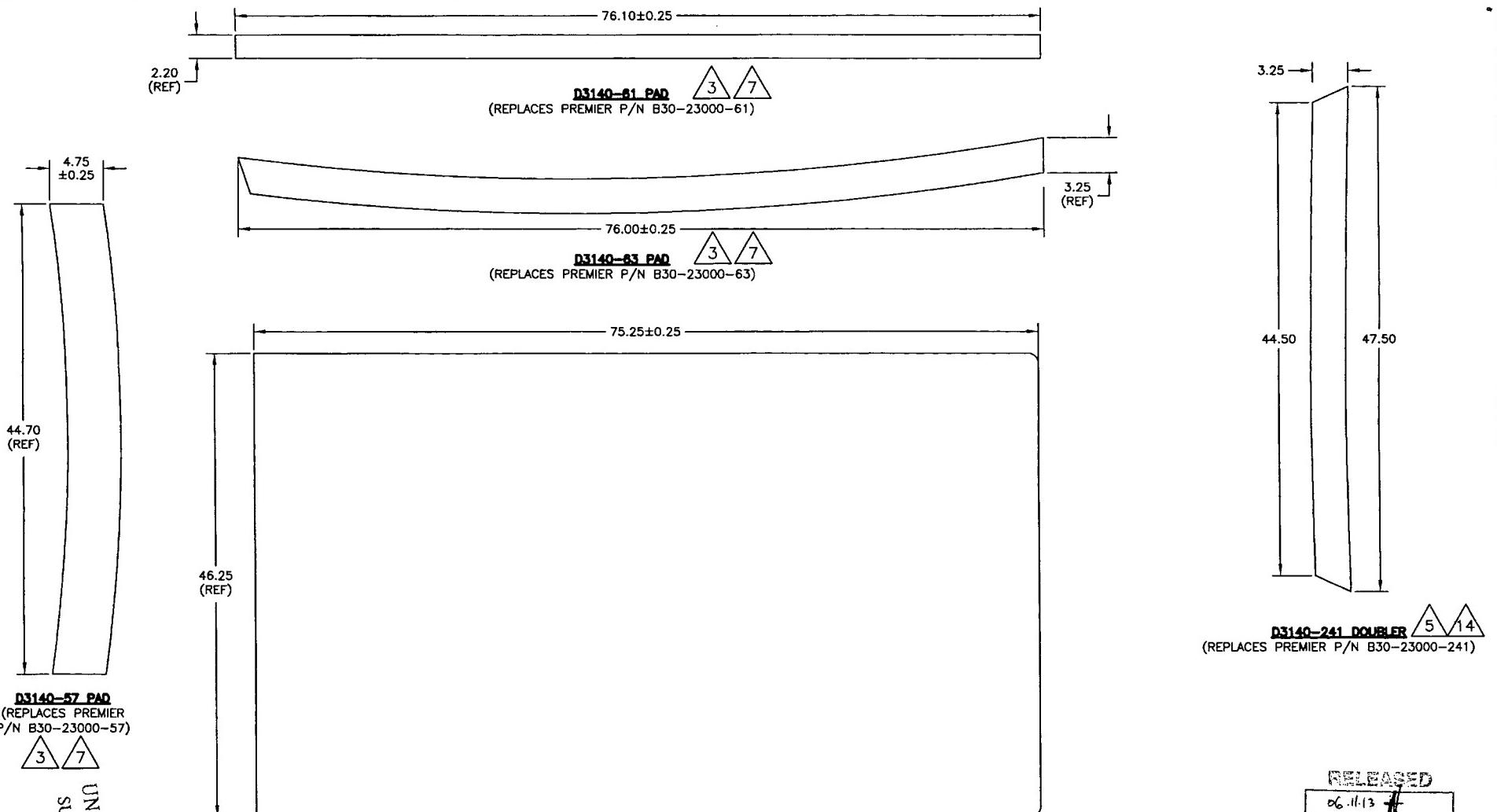


D3140-85 ANGLE 6
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED		REV. F
SJ.JH	H	D3140	SHEET 6 OF 7
DATE		TITLE	SCALE
06.10.06		DOOR	NTS



RELEASED

06.11.13

DESIGN	4	DRAWN BY	CB	DART	DART AEROSPACE LTD. HAWTHORPE, ONTARIO, CANADA
CHECKED	JLJ	APPROVED		DRAWING NO.	REV. F
DATE	06.10.06	TITLE	D3140	SHEET 7 OF 7	SCALE
			DOOR	NTS	

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 34377

DART AEROSPACE LTD	Work Order:	34377
Description: DOOR	Part Number:	D 3140-103
Inspection Dwg:	Rev: R F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	RB	Audited by:	EP	Prototype Approval:	u/a
Date:	07-09-02	Date:	03/09/04	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	